

Ship 12/06

Dart Aerospace Ltd.

Date: Thursday, 05/06/2008 10:28:58 AM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEBBING TIDY
Job Number	: 39718		
Estimate Number	: 11381		
P.O. Number	:	Part Number	: D32153
This Issue	: 05/06/2008 S.O. No. :	Drawing Number	: D3215 REVD
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 35283	Material	:
Written By	:	Due Date	: 12/06/2008 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est. A 04.01.06 New issue KJ/RF Est Rev:B Now on Waterjet 06-07-03 JLM est rev C ecn 940 07.06.12 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0271 sf(s)/Unit Total: 0.2709 sf(s)  
5052-H32 .040 Sheet  
Material: 5052-H32 (QQ-A-250/8) 0.040" thick  
(M5052H32S.040)  
Identify for D3215-3A  
Batch: 104921 13 8-6-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3215 (D3215-3A)  
Dwg Rev: P 13 8-6-6  
Prog Rev: D

2-Deburr if necessary

3-Identify as D3215-3A

(29)  
SB 08/06/06

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/06/06 (29) coantes

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 10:28:58 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 39718

Part Number: D32153

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0084 sf(s)/Unit Total: 0.0840 sf(s)  
5052-H32 .040 Sheet  
Batch: M104921

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D3215-3B (2.130" x 0.530" ) as per dwg D3215

2-Deburr

3-Identify as D3215-3B

*Boh/06/06 (29)*

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*✓ 08/06/06 4 29*

8.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

*SD 08/06/06 (29)*

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*8 08/06/06 (29)*

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004  
A/R AL ROD BATCH: m06834

Identify as D3215-3

Grind flush

*Sh 08-06-209 29*

*SAD 08/06/09 29*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 10:28:58 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 39718

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-06-10

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/10 (24) count

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/10 (24)

14.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:15  
320 OF  
11:45

M-1 08/06/10

(24x)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/10 (24)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

R 08/06/10 (24)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



C 208/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

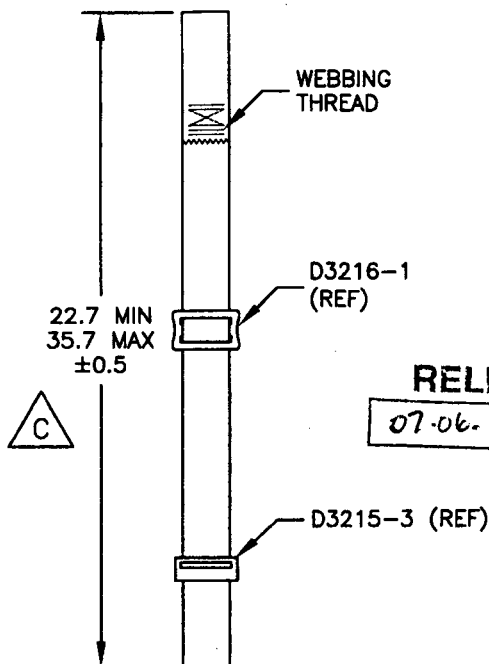
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

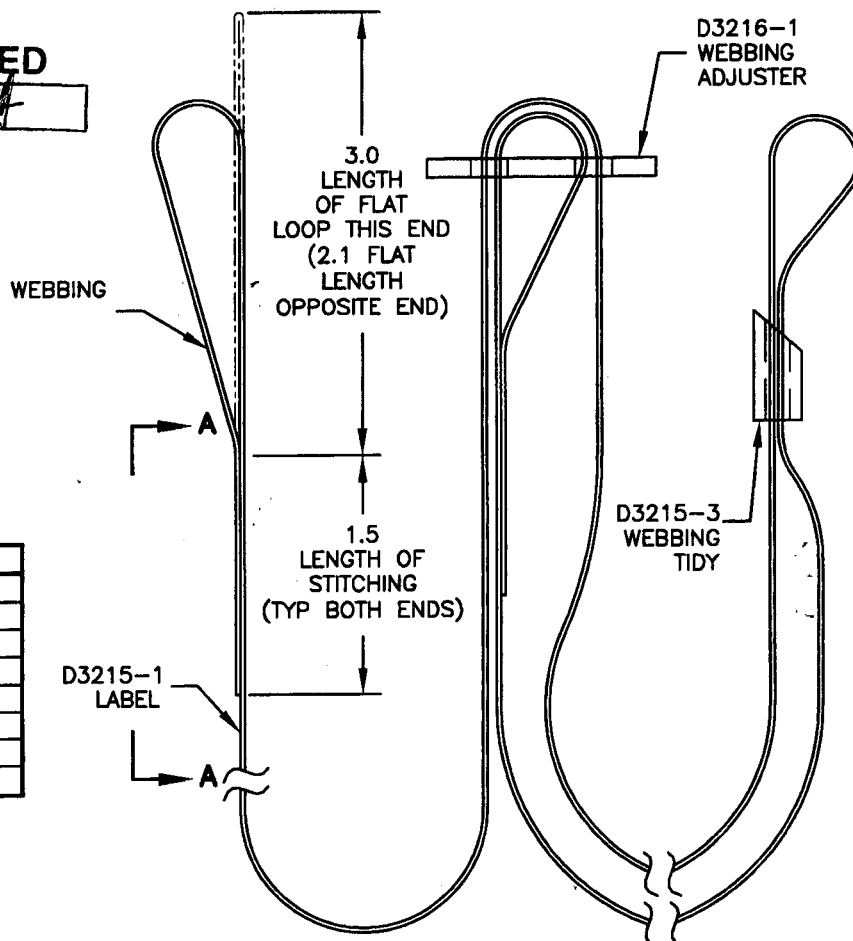
DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 1 OF 3
DATE 07.03.27	TITLE BELT ASSEMBLY	SCALE NTS	
A	03.09.19	NEW ISSUE	
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING	
D	07.03.27	ADD WEBBING SUPPLIER; ADD LABEL THREAD AND MATERIAL; IN VIEW A-A, 1.4 WAS 1.8; ADD -3A AND -3B; UPDATE TOLERANCES	



**ASSEMBLY DETAIL**  
NOT TO SCALE

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3215-041	BELT ASSEMBLY
AS REQ'D	SEE NOTE 1	WEBBING
AS REQ'D	SEE NOTE 1	WEBBING THREAD
AS REQ'D	SEE NOTE 1	LABEL THREAD
1	D3215-1	LABEL
1	D3215-3	WEBBING TIDY
1	D3216-1	WEBBING ADJUSTER



**D3215-041 BELT ASSEMBLY:**

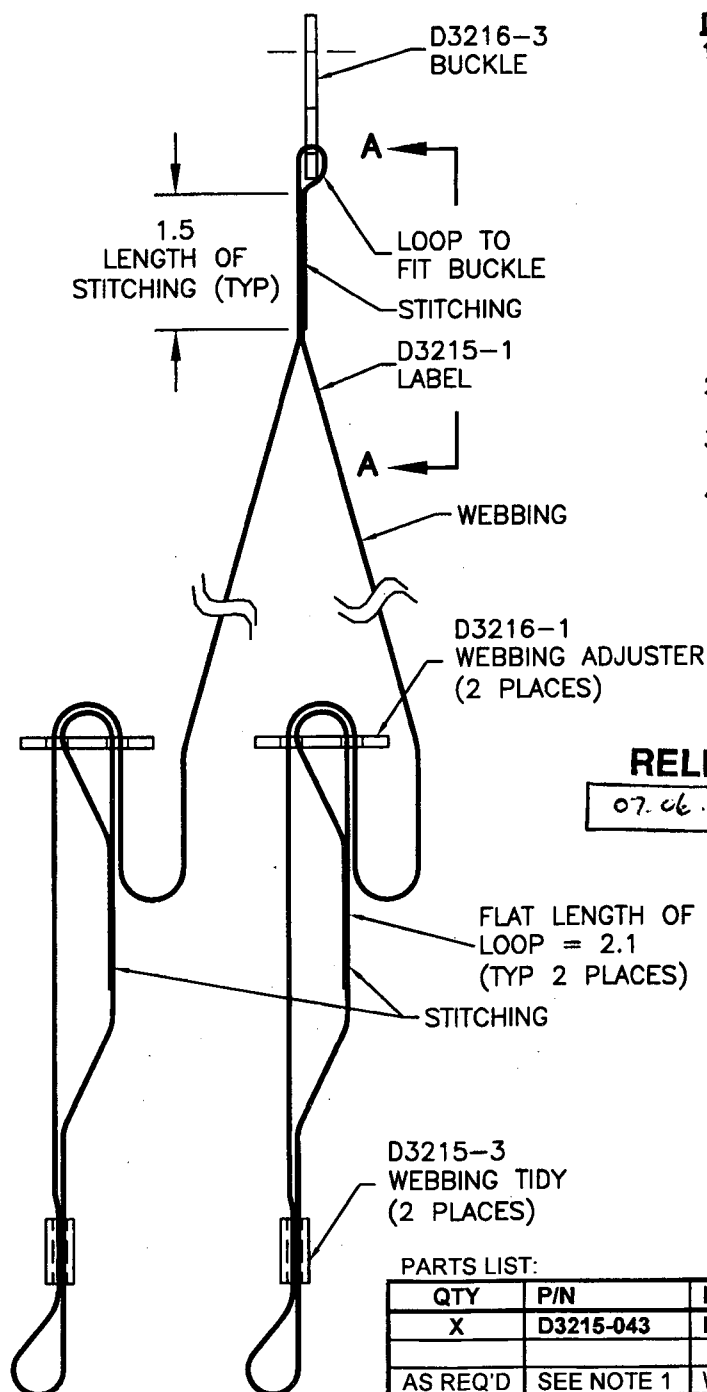
- MATERIAL: WEBBING = LAGRAN CANADA INC. 26472, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN  
OR BELT TECH CANADA INC. 27039, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 6000 lb MIN  
WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD  
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F, BLACK NYLON THREAD
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- SEE SHEET 3 FOR VIEW A-A


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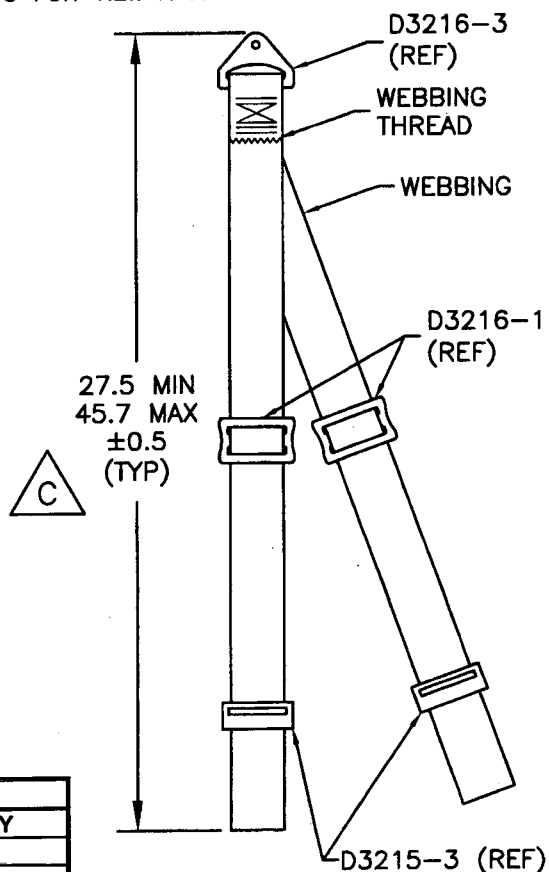
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DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3215	REV. D SHEET 2 OF 3
DATE 07.03.27		TITLE BELT ASSEMBLY	SCALE NTS

**D3215-043 BELT ASSEMBLY:**

- 1) MATERIAL:  
WEBBING = LAGRAN CANADA INC. 26472, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN  
OR BELT TECH CANADA INC. 27039, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 6000 lb MIN  
WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD  
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F, BLACK NYLON THREAD  

- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) SEE SHEET 3 FOR VIEW A-A

**RELEASED**07.06.07 *H***ASSEMBLY DETAIL**  
NOT TO SCALE**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3215-043	BELT ASSEMBLY
AS REQ'D	SEE NOTE 1	WEBBING
AS REQ'D	SEE NOTE 1	WEBBING THREAD
AS REQ'D	SEE NOTE 1	LABEL THREAD
1	D3215-1	LABEL
2	D3215-3	WEBBING TIDY
2	D3216-1	WEBBING ADJUSTER

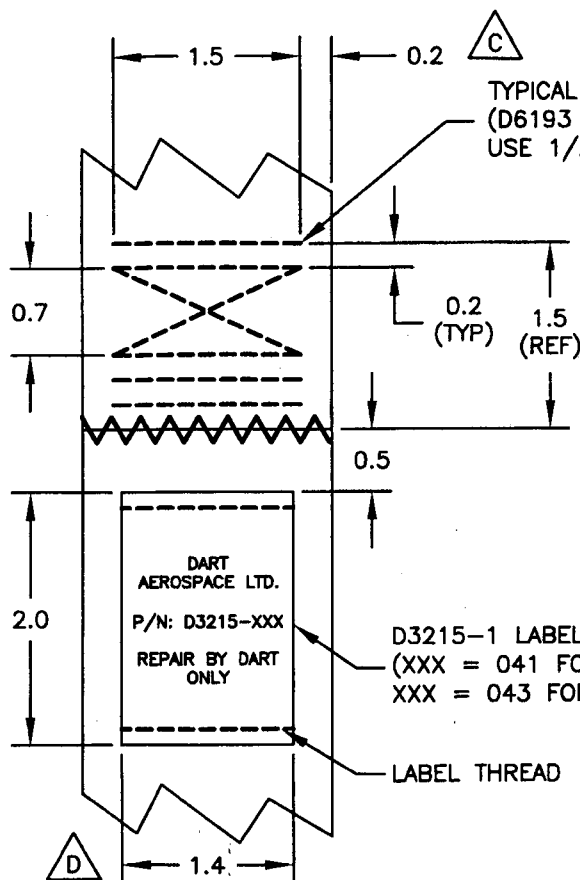
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**DART**

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 3 OF 3
DATE 07.03.27	TITLE HARNESS ASSEMBLY		SCALE 3:2

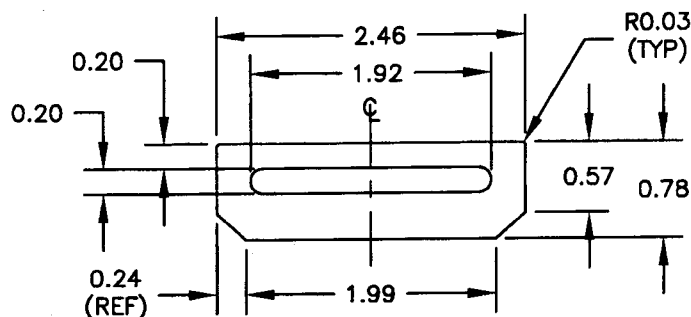
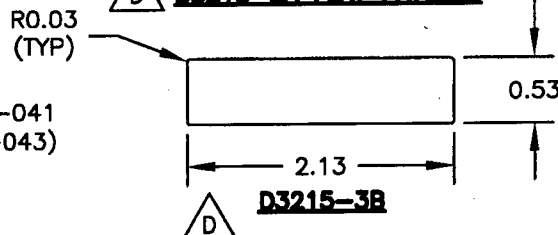
**VIEW A-A****D3215-1 LABEL:**

- 1) MATERIAL: WHITE TYVEK OR WHITE POLYESTER WHICH MEETS FMVSS 302
- 2) USE 1/8 BLACK LETTERING
- 3) CENTER ON BELT WIDTH

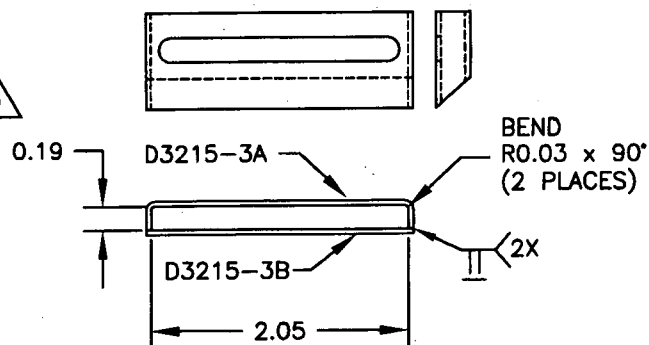
**RELEASED**07.06.07 *[Signature]***GENERAL NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

TYPICAL STITCHING PATTERN  
(D6193 TYPE 301, 7-10 STITCHES PER IN.  
USE 1/2 MIN. BACKSTITCH, NO LOOSE THREADS)

**D3215-3A FLAT PATTERN****D3215-3A/-3B NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC. M5052H32S.040)
- 2) BEND D3215-3A PER D3215-3

**D3215-3 WEBBING TIDY****D3215-3 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	39718
<b>Description:</b> WEBBING TIDY	<b>Part Number:</b>	D3215-3
<b>Inspection Dwg:</b> D3215-3 <b>Rev:</b> D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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[illegible]

Measured by: KB	Audited by: J	Prototype Approval: n/g
Date: 2-6-5	Date: 08/06/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	